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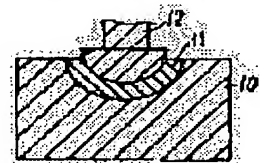
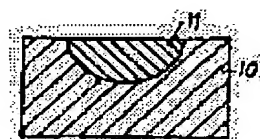
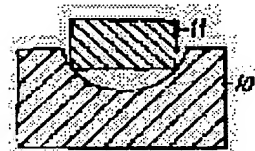
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(54) MANUFACTURE OF THICK CHINA AND PORCELAIN PRODUCT

(57)Abstract:

PURPOSE: To enable high-precision molding, by a method wherein, after filling of a solid material comprised of china and porcelain raw materials into a bottom force by giving a vibration under a state where the solid material is put within the bottom force, an iron having an inside form of a product is applied to the upper part of the above-mentioned material by pressurizing the same and the china and porcelain product is molded.

CONSTITUTION: After obtaining of a cake obtained by dehydrating and conditioning water content of a material comprising of ceramic raw materials to an extent of 18-22% by, for example, with a filter press, the case is extrusion- molded into a cylindrical solid material by a vacuum extruder. Then the solid material 11 cut into fixed sizes is set within bottom force 10 forming an outside form of a product provided on a vibration giving device such as a clay placing machine. The material 11 is filled compactly into the bottom force 10 by vibrating the bottom force 10 under this state. Then the vibration is suspended, a flat iron 12 having an inside form of a product is pressed onto the material 11 and the inside form is made. Then a molded body is taken out from the bottom force 10, drying and firing are performed as in the past and the final product is completed.



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